Date:

Tuesday, 8/1/2006 11:29:35 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28062B

Estimate Number P.O. Number

: 10729

:NIA

: 8/1/2006 This Issue

Prsht Rev. : NIA First Issue

: 27050B **Previous Run**

Written By

Checked & Approved By

: Est. E 03.02(28)

Type

S.O. No. : NIA

: SMALL/MED FAB

Part Number **Drawing Number**

Reformat; Incorporated D2324-3 & D2324-5

Project Number

Drawing Name

Drawing Revision

Material Due Date

AI4: : 8/18/2006

: N/A

: C

: STRAP

: D23245

: D2324 REV C

Qty:

40 Um:

Each

Comment

J/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

WATER JET 1.0

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2324

Dwg Rev:__ Prog Rev:_

2-Deburr if necessary

SAD

06:08:09

2.0

M304S16GA

304/316 .063 Sheet

304/316 .063 Sheet

Comment: Qty.:

0.0184 sf(s)/Unit

Total: 0.7360 sf(s)

Batch# M19059

40

3.0

QC2



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

540

70)

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Page 1

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE	Ву		By Date		Approval Mfg / Design Mgr	Approval QC Inspector		
		Se									
		- :		,							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	Approval	Approval		
DATE	STEP	Section A	Initial Design Mgr		Action Description Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector	
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				161						

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: <u>이 / 8 원 / 1</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Tuesday, 8/1/2006 11:29:35 AM Date: ⊌ser: Kim Johnston **Process Sheet** Drawing Name: STRAP Customer: CU-DAR001 Dart Helicopters Services Job Number: 28062B Part Number: D23245 Job Number: Seq. #: **Machine Or Operation:** Description: PACKAGING 1 PACKAGING RESOURCE #1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ____ 7.0 DC Jab 15 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace Ltd

W/O:		÷	WO	RK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCF	₹)			
		Description of NC	Corrective Action Section B			Vorifi	ication	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign 8	Sect	Verification Section C		QC Inspector
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Part No	o:	PAR #:	Fault Category	/:NCR: \	'es No	DQA:	Market Company	Date:	
NOTE: D	lata & initia	al all entries) A · N/C · C	laaad.		Date	

DART AEROSPACE LTD	Work Order:	28062B
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	20.38	V		R-6	
Ø0.257	+0.006/-0.001	Ø0.259	1		Vern	
Ø0.191	+0.005/-0.001	00.192	V		Vern	
0.750	+/-0.010	0.756	V		Vern	
0.375	+/-0.010	0.379	1		Vern	
1.875	+/-0.010	1.878	/		Vern	
3.000	+/-0.010	3.004	/		Vern	
3.375	+/-0.010	3.380	/		Vern Vern	

Measured by:	SAD	Audited by:	36	Prototype Approval:	N/A
Date:	06:08:09	Date:	06.08.09	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	06.06.05	New Issue	KJ/JLM	
			777	777

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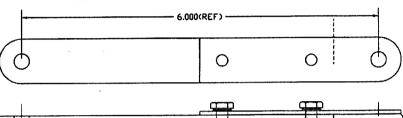
DRAWN BY DESIGN DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA B WILLIAMS PH CHECKED APPROVED DRAWING NO. D2324 SHEET 1 OF 1 SCALE DATE TITLE **STRUT** 04.12.14 94.11.08 **NEW ISSUE** Α 96.05.07 UPDATE MATERIALS В UPDATE NOTES

D2324-5

AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1)

(TWO PLACES)

RELEASE 04.12.16



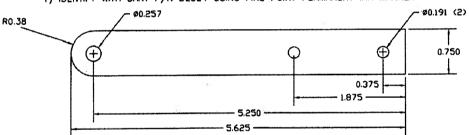
04.12.14

C

D2324 STRUT ASSEMBLY

D2324-3

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

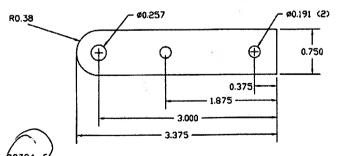
6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL: (REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

ALL DIMENSIONS ARE IN INCHES 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE